

Date: Monday, 7/16/2007 2:42:17 PM  
 User: Kim Johnston

## Process Sheet

32

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH AFT X-TUBE 412  
 Job Number : 33541  
 Estimate Number : 10559  
 P.O. Number :  
 This Issue : 7/16/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D412664203  
 First Issue : 11 Type : LANDING GEAR Drawing Number : D412-664-243 REV D  
 Previous Run : 33540 Drawing Revision : D  
 Material :  
 Due Date : 8/5/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 07.07.17  
 Comment : Est Rev: E 04.02.16 Reformat; Added D3189-1 K/DS  
 Est Rev: F 06-03-29 Remove Comments on Pick List JLM  
 Est Rev: G 06.12.08 per ECN 886 EC  
 Est Rev: H 07-04-30 As per Rev D JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



KS 07.07.30

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

J.L. 07/10/09

2.0

D6009129

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6009-129 Crosstube B25668

Check OD = 3.500"; ID = 2.250"

J.L. 07/10/09

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA166

2-Turn first side as per Folio FA166

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

J.F. 07/10/11

4.0

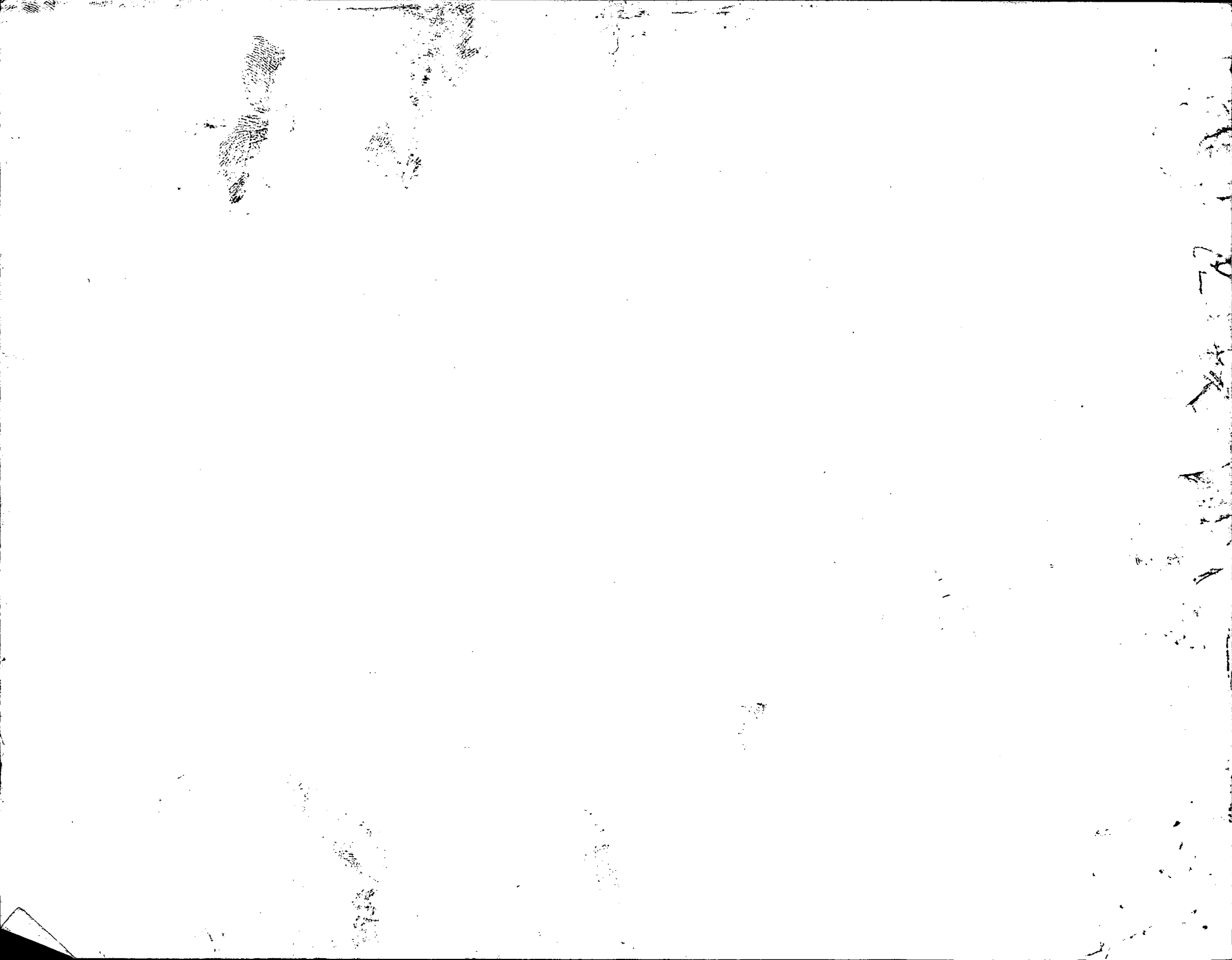
QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/10/11



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33541

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA166

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243.

3- Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243

Inside of

Cuff(Donot engrave on outside of tube)

J.F. 07/10/11

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/10/11

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

FA-10-12 @

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JD 7-10-11

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FA-10-12 @

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

NIA

For ultrasonic test only - Absent @ seq 15.0

11.0

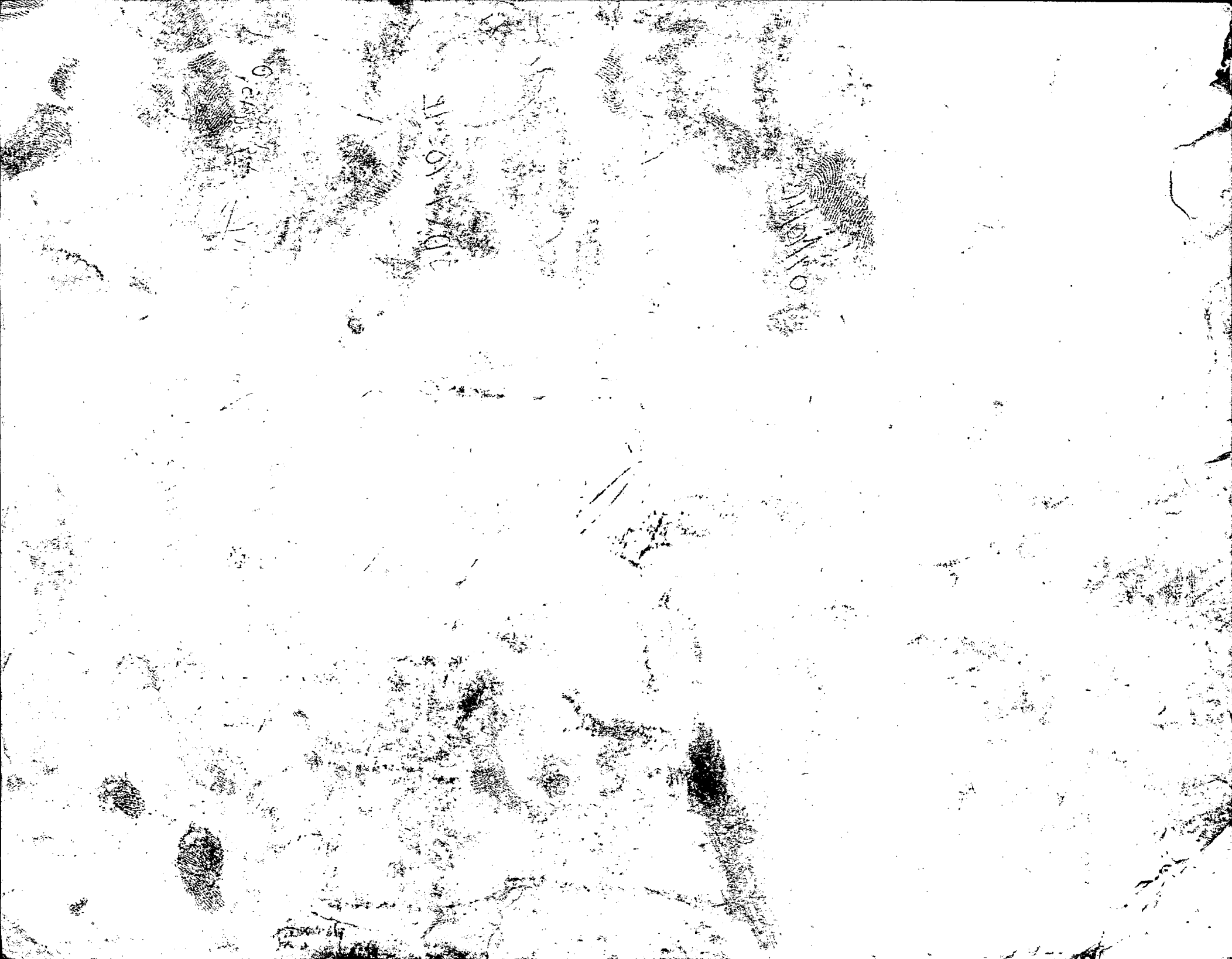
QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect work & Chemical conversion Coat

NIA



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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33541

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

EL 7-10-15

13.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

06-01-08

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

SM  
8-1-9

AWM - 08-01-15

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 08-01-15

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/17 (4)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/17 (4)

18.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5502 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 08/01/21 @

Date: Monday, 7/16/2007 2:42:17 PM  
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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33541

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

*C 08/01/21 D*

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

*C 08/01/21 (XL)*

21.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*RT 08-02-04*

*RT 08-02-06*

22.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

*08/01/14 D*

23.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0492 sf(s)/Unit Total : 0.0492 sf(s)

Rubber Cushion (per sq ft)

.630" x5.70" x2pcs

Batch:

*35126*

*RT 08-02-12*

24.0

D285600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(Cut to 10.090") Abrasion Strip

*36398*

*RT 08-02-12*

25.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number

Description

Batch

1 D2896-1

Support

*RT 08-02-12*

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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33541

Part Number: D412664203

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

26.0	D31891	Chafing Shield
------	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield

36065

25 08-02-12

27.0	MS2192028	Clamp(per MIL-DTL-8783C)
------	-----------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp

106864

25 08-02-12

28.0	MS2192030	clamp(per MIL-DTL-8783C)
------	-----------	--------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 106810

25 08-02-12

29.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
------	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 106675

Expiry Date: 08-11-01

25 08-02-12

2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

30.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

08/21/14

31.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Date: Monday, 7/16/2007 2:42:17 PM

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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33541

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: 106516

AS 08/02/14 (X)

33.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: 104427

AS 08/02/14 (X)

34.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: 106883

AS 08/02/14 (X)

35.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

Batch: M104374

All same Batch.

AS 08/02/14 (X)

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/02/15 (X)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

\*\*\*\*\*Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date  
\*\*\*\*\*

Time & date of packaging: 08/02/15 @ 10:00 AM

Location: G

PPP Rev: 5

8/2/15 50 (X)



Date: Monday, 7/16/2007 2:42:17 PM

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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 33541

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/02 (1)

Job Completion



2008/2/19

(1)

W

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 33541
<b>Description:</b> Crosstube Assembly (412 High Aft)	<b>Part Number:</b> D412-664-243
<b>Inspection Dwg:</b> D412-664-243 <b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.688"	✓			
	2.748	+0.005/-0.000	2.753"	✓			
	2.884	+0.005/-0.000	2.889"	✓			
	3.019	+0.005/-0.000	3.023"	✓			
	3.163	+0.005/-0.000	3.166"	✓			
	3.308	+0.005/-0.000	3.311"	✓			
	3.429	+0.005/-0.000	3.431"	✓			
	2.990	+0.005/-0.000	2.994"	✓			
	2.618	+0.005/-0.000	2.622"	✓			
	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	5.063	✓			
	R0.500	+/-0.010	5.500	✓			
	4.971	+/-0.030	4.972"	✓			
SIDE B	2.684	+0.005/-0.000	2.689"	✓			
	2.748	+0.005/-0.000	2.753"	✓			
	2.884	+0.005/-0.000	2.889"	✓			
	3.019	+0.005/-0.000	3.024"	✓			
	3.163	+0.005/-0.000	3.167"	✓			
	3.308	+0.005/-0.000	3.311"	✓			
	3.429	+0.005/-0.000	3.432"	✓			
	2.990	+0.005/-0.000	2.994"	✓			
	2.618	+0.005/-0.000	2.622"	✓			
	0.200	+/-0.010	.200	✓			
	R0.063	+/-0.010	5.063	✓			
	R0.500	+/-0.010	5.500	✓			
	4.971	+/-0.030	2.977"	✓			
	124.09	+/-0.020	124.09	✓			

<b>Measured by:</b> JI/J.F.	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/10/09	<b>Date:</b> 07-10-12	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM	

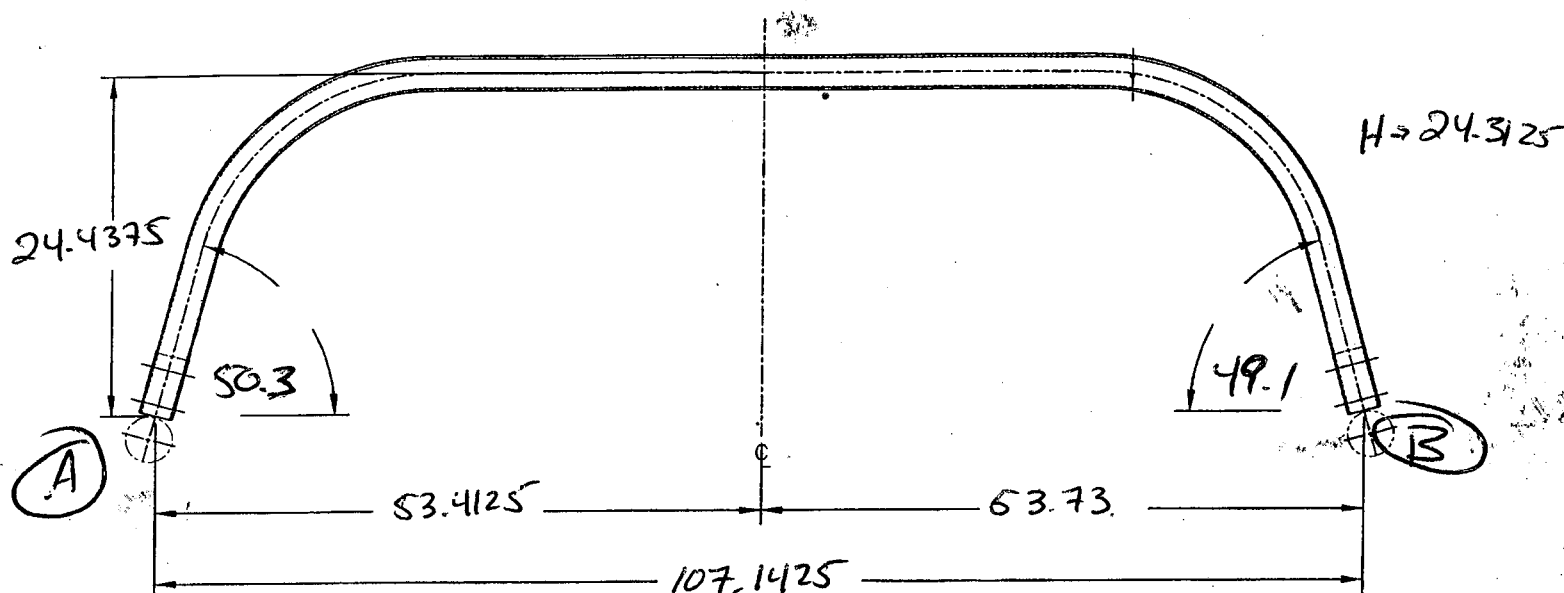
5-15

John May 20 1864

11/11/2011 11:11:11

DART AEROSPACE LTD	Work Order:	33541
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
Tube is slightly uneven by 0.125". Side 'A' is higher. Tube fits well in the drill jig, but is 0.125 off true center.
- See E-impil

QC15 Inspection	
Date	08.01.08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	



**DART**

DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>QP</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D412-664-243	REV. D SHEET 1 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE NTS
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	
D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570	

**RELEASE**07.04.24 **[Signature]**

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
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WORK ORDER  
NO. **33541**

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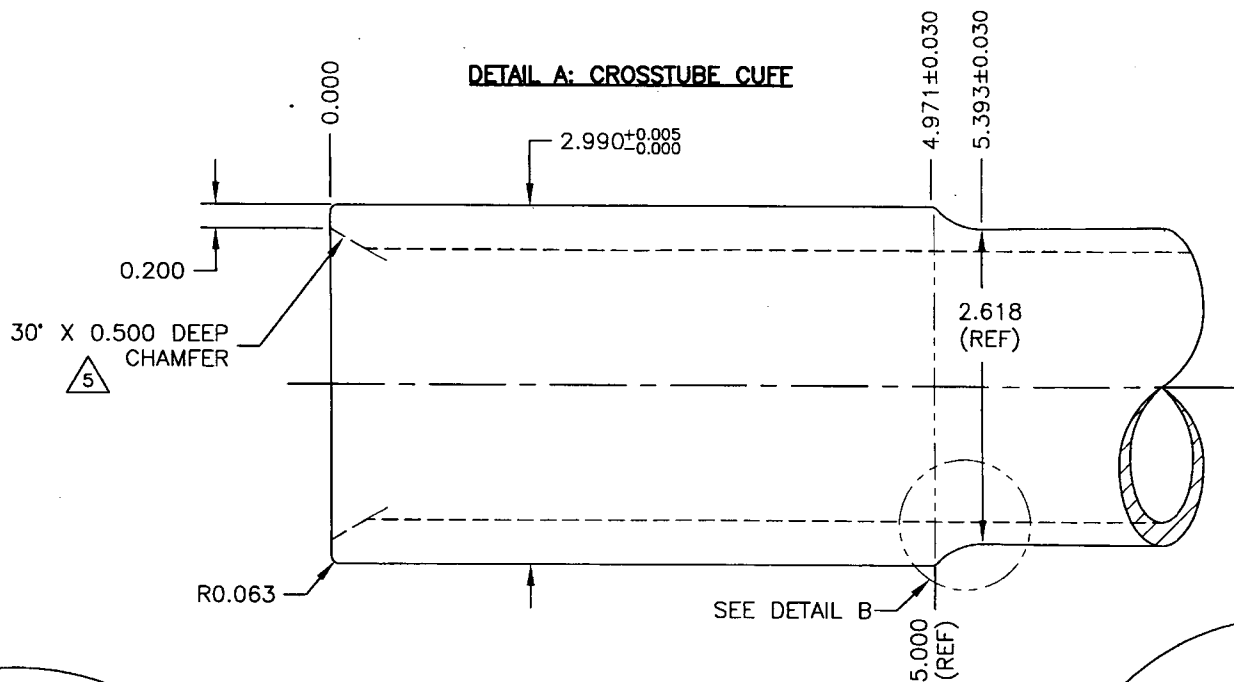




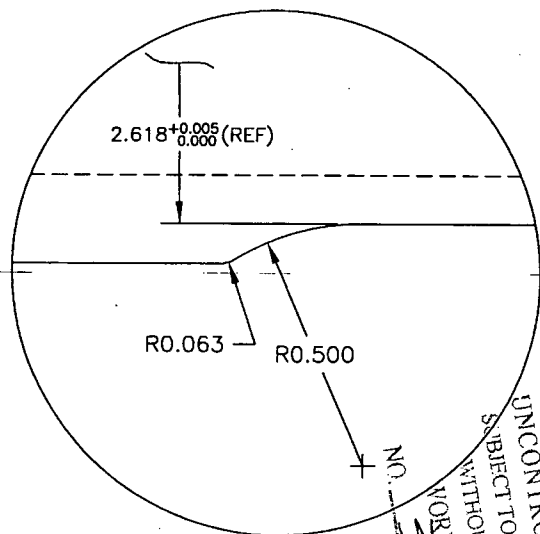


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07.04.244P  
PER ECN 889

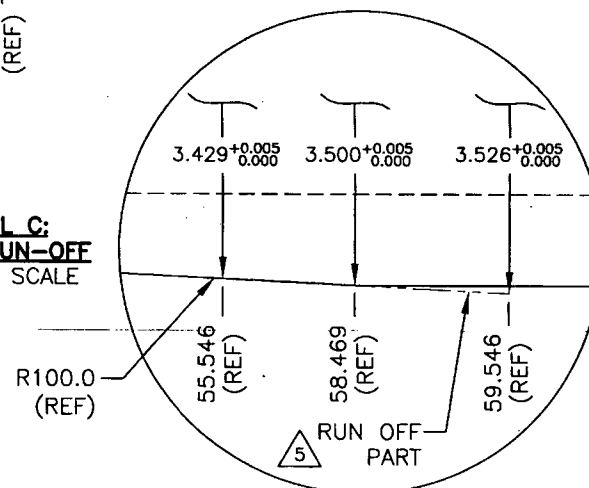
**DETAIL A: CROSSTUBE CUFF**



**DETAIL B: CUFF  
TRANSITION  
SCALE 4:1**



**DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE**

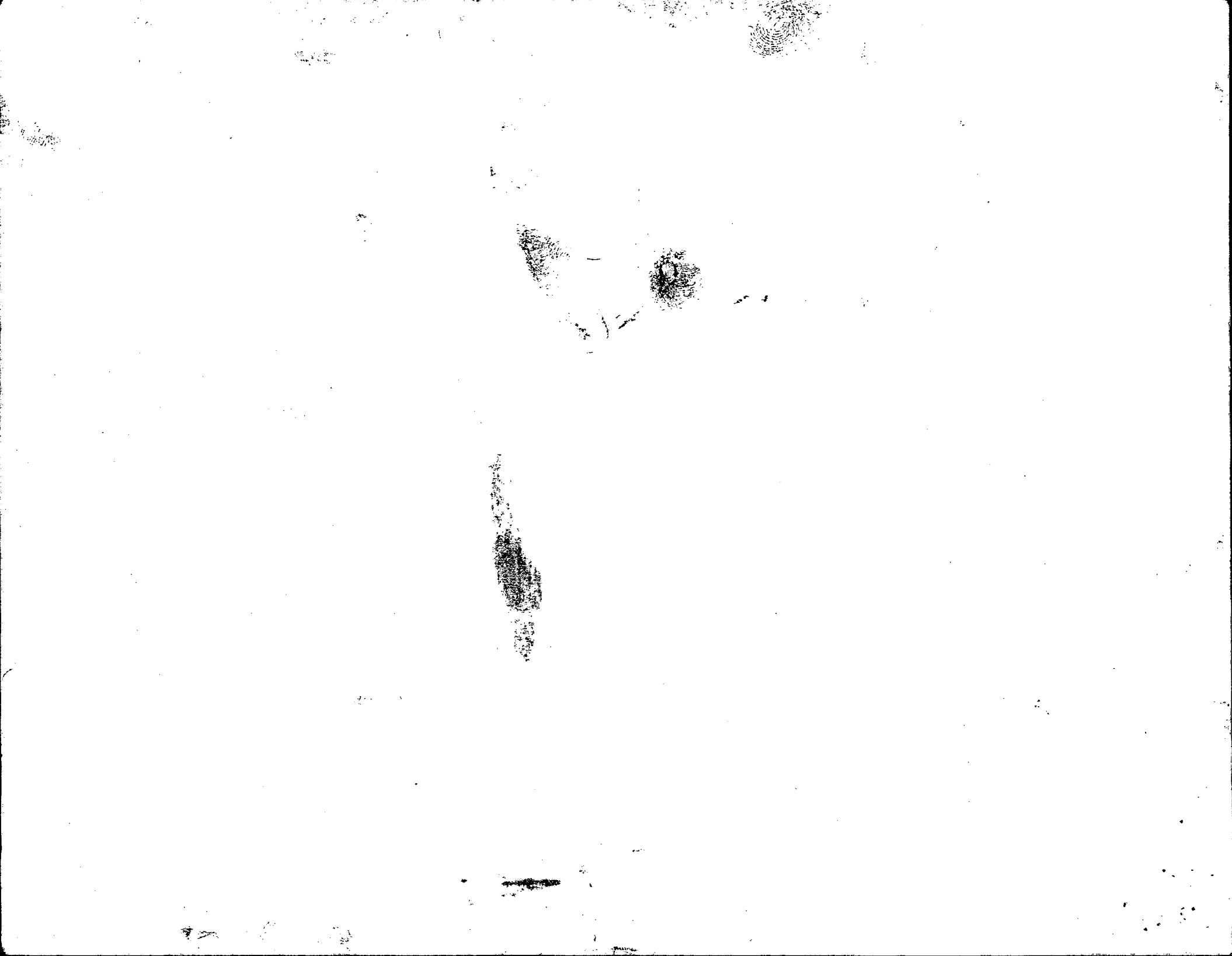


NO. 33241  
WORK ORDER  
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DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA	REV. D
CHECKED J	APPROVED J	DRAWING NO. D412-664-243	SHEET 3 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:1



D412-664-203 xtube, b/n 33541 is acceptable.

by C.P. on 08.01.08.

E-mail did not print  
correctly. See back up  
in Eng. Approval Detcher.

  
08.01.08





## LIQUID PENETRANT TEST REPORT

P- 09828

PAGE 1 OF 1

CLIENT Dart Aerospace DATE 18 Jan 2008 TIME AM ☐ PM ☐

ATTENTION Linda Lacelle ACUREN JOB NO. 188-2-1209

ADDRESS 1270 Aberdeen st POWO No. \_\_\_\_\_

Hawkesbury Ont. WORK LOCATION Hawkesbury

PROJECT 402 High AFT x-Tube assembly ACCEPTANCE STD. ASTM 1417/AST-3 REV./DATE 2005

ITEM(S) EXAMINED 206 L AFT X-TUBE High AFT X-TUBE 412

Sobs # 36383, 36384, 36385, 36386, 36379, 36381, 33541

JOB DESCRIPTION \_\_\_\_\_ PROCEDURE NO. LT-XXXX REV./DATE \_\_\_\_\_ TECHNIQUE NO. LT-XXXX-XXX REV./DATE \_\_\_\_\_

PART NO. D407667205 D206667203, D412667203 MATERIAL ALODYNE ALUMINUM THICKNESS

SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON

100% OF EXTERNAL SURFACE

## TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☐ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED

FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 9178 ☐ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☐ AMBIENT < 2 fc

PENETRANT ZL67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☒ FLASHLIGHT ☐ TROUBLELIGHT ☒ OUTPUT > 100 fc @ SURFACE

PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER \_\_\_\_\_

DEVELOPER SKDS2 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N \_\_\_\_\_ CAL DUE DATE MAR 08

DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

## TEST SURFACE

SURFACE CONDITION ☒ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL

SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM	COMMENTS	ACCEPT	REJECT
36383	ACCEPTABLE		
36384	ACCEPTABLE		
36385	ACCEPTABLE		
36386	ACCEPTABLE		
36379	ACCEPTABLE		
36381	ACCEPTABLE		
33541	ACCEPTABLE		

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE _____		DTR # _____	
TECHNICIAN (SIGNATURE): _____		REPORT REVIEWED BY: _____	
NAME (PRINT): <u>Frederick Chagnon</u>	1 <sup>st</sup> TECHNICIAN	NAME	INITIALS
CGSB LEVEL <u>II</u> SNT LEVEL _____	2 <sup>nd</sup> TECHNICIAN		
CGSB REG. NO. <u>10560</u>	CGSB REG. NO. _____		